Work Order ID 51805

Thursday, September 03, 2009 11:44:12 AM

Item ID: D350-636-012
Revision ID: F
Item Name: Skidtube RH
Start Date: 9/3/2009 **Start Qty:** 1.00
Required Date: 9/15/2009 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Approvals: **Process Plan:** RL MK **Date:** 9-9-09 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL MK	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy blue file and type labels per PPP D350-636-012 CHG 004 Sep 10 09								

Draw Nbr	Revision Nbr
D2750	Rev F

HJ for BG 09/10/01

51805

Work Order ID 51805

Thursday, September 03, 2009 11:44:12 AM

Item ID: D350-636-012
Revision ID: F
Item Name: Skidtube RH
Start Date: 9/3/2009 **Start Qty:** 1.00
Required Date: 9/15/2009 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes	0.00							
Skidtubes									

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

BE 09/09/10

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

BE 09/09/14

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R□□□ Aluminum Rod □ M111682

10-Grind welds flush as per Dwg D2750

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11- scribe batch #.								
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				(40)	0		
	Memo	0.00							
130 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				(40)	0		
	Memo	0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				(1)	0		
	Memo	0.00							

=> 8 09/09/14

=> 8 09/09/14

- Ann 9-9-15

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				(1)	0	RE 09/09/15	
QC	**Memo**	0.00							
Quality Control									

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Item Name: Skidtube RH

Start Date: 9/3/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00				1	0	-	AWM 9-7-15
Skidtubes	Skidtubes	0.00							

Skidtubes

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015 M112391
A/R □□□ Sikaflex-291 batch:_____ □□□
exp. date: 10-02-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)
A/R□□□ Aluminum Rod batch: M111682 ~~BE~~ 09/09/16

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

AM 09-09-28

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Required Date: 9/15/2009 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Deburr holes a. m 09-09-29 (V)								
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00				(4)	4		
180 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				(4)	4		
190 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00				(4)	4		

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Required Date: 9/15/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112260 **Memo** START TIME: 3:30pm OVEN TEMPERATURE: 320°F FINISH TIME: 4:00pm	0.00 0.00				(X1)	0		
210 QC Quality Control	QC3- Inspect Part Finish **Memo** Inspect for foreign object per QSI 024	0.00 0.00				(0)	0		
220 HandFinish Hand Finishing	HandFinishing **Memo** Install inserts as per dwg D2750	0.00 0.00				X1			

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Required Date: 9/15/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00				X1			
HandFinish	**Memo**	0.00							
Hand Finishing	1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: N/A 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M112391 EXP DATE: 10/20 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M101223 5-Coat all exposed fasteners with "LPS Procyon" batch: M104251								
240	QC5- Inspect part completeness to step on W/O	0.00				(41)	0		
QC	**Memo**	0.00							
Quality Control									

MD 09/09/30

JS 09/09/30

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Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00		(12)		9/10/1		50	
Packaging	**Memo**	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00 9/8/10/01				(12)	0		
QC	**Memo**	0.00							
Quality Control									
270	Packaging	0.00				9/10/12		50	
Packaging	**Memo**	0.00							
Packaging	Package as per PPP D350-636-012								

Work Order ID 51805

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Start Date: 9/3/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00				_____	09/10/05		
QC	**Memo**	0.00							
Quality Control									

MF 09-10-02

Picklist Print

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Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	8,785.000	38.0000			
Insert												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	8785	
107441	16	
110768	8769	

X38 MO 09/09/30

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A		Purchased	No			230	Each	646.0000	34.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	646	
111424	8	
111707	338	
112314	200	
112489	100	

X34 MO 09/09/30

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A		Purchased	No			230	Each	1,048.000	4.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1048	
110372	72	
111982	976	

X4 MO 09/09/30

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Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A		Purchased	No			230	Each	172.0000	4.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code		
OFFSHORE				
FG	2			
103964	2			
Main Warehouse				
ST	170			
110105	4			
110155	14			
110665	1			
110865	51		X4	MD 09/09/30
111605	50			
111649	50			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C35A		Purchased	No			230	Each	167.0000	1.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	167			
102180	1			
106896	1			
110105	65		X1	MD 09/09/30
110847	100			

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Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			230	Each	2,450.000	38.0000			
washer												

Warehouse Location	Loc Qty	Loc Code	
OFFSHORE	112612		X38 MO 09/09/30
FG	100		
103585	100		
Main Warehouse			
FP	-44		
112116	-44		
Main Warehouse			
ST	2394		
~~112116~~	2394		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L		Purchased	No			230	Each	330.0000	1.0000			
WASHER												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	330		
104093	2		
107520	4		
110139	29		
110372	36		X1 MO 09/09/30
110584	100		
111424	159		

Picklist Print

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Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			
Bushing												

Warehouse Location	Loc Qty	Loc Code			
Main Warehouse					
ST	272				
34817	2				
36230	8				
37303	1				
39587	2				
40726	2				
41114	2				
42778	19				
43754	2				
44893	37				
45556	69		X8	MO	09/09/30
46695	18				
48278	110				

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3488-042RevB		Manufactured	No			230	Each	9.0000	1.0000			
Blade Fitting Assembly, RH												

Warehouse Location	Loc Qty	Loc Code			
Main Warehouse					
ST	9				
~~45043~~	1		X1	MO	09/09/30
44531	8				

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Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-041RevC		Manufactured	No			230	Each	3.0000	8.0000			
Plug Assembly												
				Warehouse Location		**Loc Qty**		**Loc Code**				
				Main Warehouse								
				ST		3						
				43816		3						
D3492-043RevC		Manufactured	No			230	Each	0.0000	8.0000			
Plug Assembly												
D3535-25RevB		Manufactured	No			230	Each	11.0000	1.0000			
Wearshoe												
				Warehouse Location		**Loc Qty**		**Loc Code**				
				Main Warehouse								
				ST		11						
				47523		11						

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Parent Item Name: Skidtube RH

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Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	21.0000	1.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	21			
45569	1			
47011	2			
47526	8			
50266	10		X1	MD 09/09/30

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	46.0000	3.0000			
Wearpad												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
FP	46			
~~48288~~	3			
~~50321~~	43		X3	MD 09/09/30

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Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA		Manufactured	No			230	Each	105.0000	8.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code			
Main Warehouse					
ST	105				
38139	6				
45353	16				
47437	83		X8	mo	09/09/30

D3791-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
Wearplate												

Warehouse Location	Loc Qty	Loc Code			
Main Warehouse					
ST	18				
47536	8		X1	mp	09/09/30
50269	10				

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Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	18	
40551	1	
47537	4	
50231	13	

XI mo 09/09/30

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA		Manufactured	No			230	Each	22.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	22	
47720	11	
50216	11	

XI mo 09/09/30

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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA Gasket		Manufactured	No			230	Each	7.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse	51608		X1 MO 09/09/30
ST	7		
46530	1		
47212	2		
47721	4		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA Gasket		Manufactured	No			230	Each	27.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	27		
46531	2		
47440	2		
47722	11		
50240	12		X1 MO 09/09/30

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Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6		Purchased	No			230	Each	1,132.000	4.0000			
NUT												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	1132			
110584	34		X4	MD 09/09/30
111424	98			
112314	1000			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8		Purchased	No			230	Each	92.0000	1.0000			
NUT												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	92			
110584	5			
111424	2			
111637	21		X1	MD 09/09/30
112243	44			
112492	20			

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Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-010		Purchased	No			230	Each	345.0000	8.0000			
O-RING												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	345	
110715	50	
110915	295	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-013		Purchased	No			230	Each	320.0000	8.0000			
O-RING												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	320	
106513	11	
111424	109	
111758	200	

Dart Aerospace Ltd

W/O: 51805		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
09/09/30		Replaced O-Ring NAS1611-010 by O-Ring D2594-3 Batch: BS1613 X8	MD	09/09/30	8		

Part No: D350-636-012 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 03, 2009 11:44:19 AM

Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A BOLT		Purchased	No			260	Each	112.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L WASHER		Purchased	No			260	Each	330.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

Picklist Print

Thursday, September 03, 2009 11:44:19 AM

Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2741RevC Blade, 350 Skidtube		Manufactured	No			260	Each	40.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	40	
20770	0	
45320	1	
47113	39	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3493-1RevA Washer		Manufactured	No			260	Each	115.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	115	
44902	15	
47710	100	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3532-1RevA Spacer		Manufactured	No			260	Each	43.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	43	
38161	2	
44904	41	

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Thursday, September 03, 2009 11:44:19 AM

Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8		Purchased	No			260	Each	92.0000	2.0000			
NUT												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L		Purchased	No			260	Each	350.0000	4.0000			
WASHER												

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
~~111819~~	300	

Dart Aerospace Ltd

W/O: 51805		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
09/09/30		for washer NAS1515H3L should be step 230	MD	09/09/30	4		S 09/11/30

Part No: D350-636-012 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 03, 2009 11:44:19 AM

Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L		Purchased	No			260	Each	129.0000	2.0000			
WASHER												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	129	
107581	34	
108964	1	
111650	94	

D2600-3-BENTRevD1		Manufactured	No			110	Each	0.0000	1.0000			
Extrusion Bent												
D2744RevC		Manufactured	No			110	Each	50.0000	1.0000			
Cap												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	50	
44892	15	
47488	35	

Picklist Print

Thursday, September 03, 2009 11:44:19 AM

Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
350 I Beam												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

B-51919 - AHM 9-9-15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2743RevB		Manufactured	No			160	Each	294.0000	8.0000			
Crossbolt Spacer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
LG	50	
50281	50	
Main Warehouse		
ST	244	
44891	2	
45555	177	
48275	65	

8 BE 9-9-16

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Thursday, September 03, 2009 11:44:19 AM

Work Order ID: 51805

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/15/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA		Manufactured	No			160	Each	112.0000	4.0000			
Cross Bolt Spacer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	112	
45560	22	
47471	35	
48276	55	

1 BE 9-9-16
3 BE 9-9-16

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA		Manufactured	No			160	Each	165.0000	4.0000			
Cross Bolt Spacer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	165	
45338	2	
47118	4	
47657	50	
48277	109	

4 BE 9-9-16

W/O 51805

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
 ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

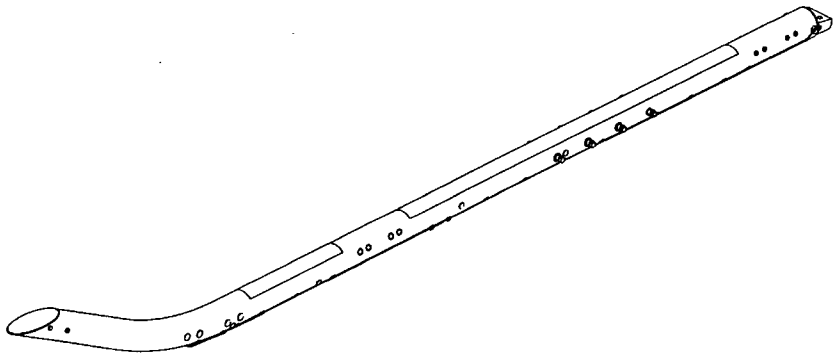
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REV.	DESCRIPTION	BY	DATE
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (36) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

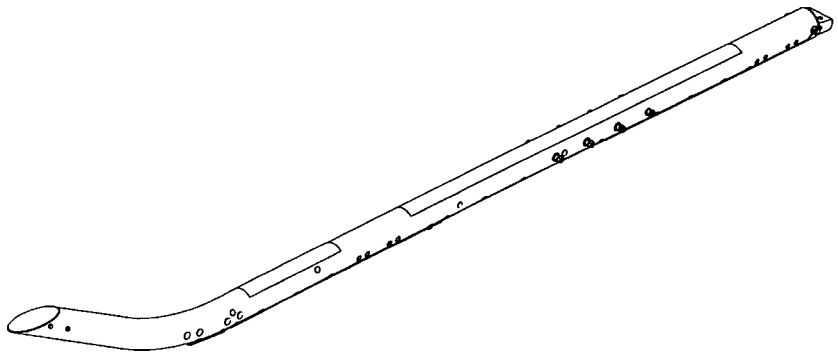
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MFG. APPR.		SHEET 1 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.07.16	

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51803



D2750-041 350 SKIDTUBE ASSEMBLY, LH



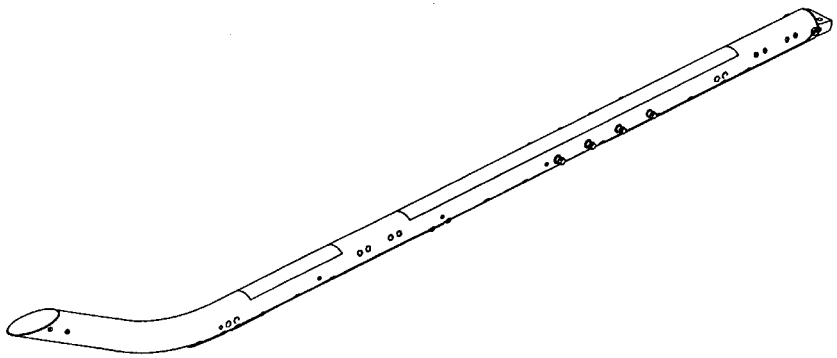
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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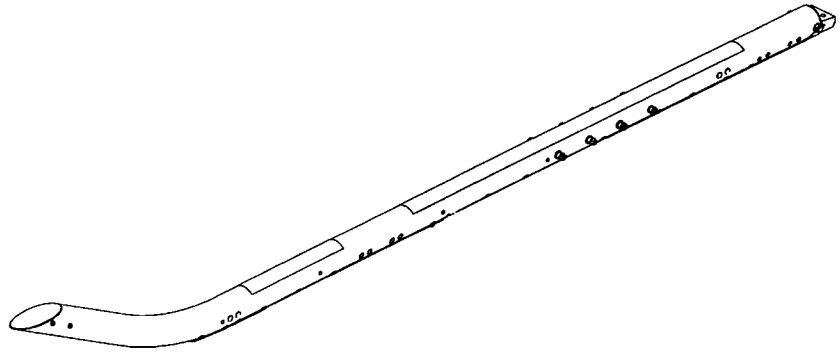
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DATE 08.07.16			

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W/O 51805



D2750-043 350 SKIDTUBE ASSEMBLY, LH



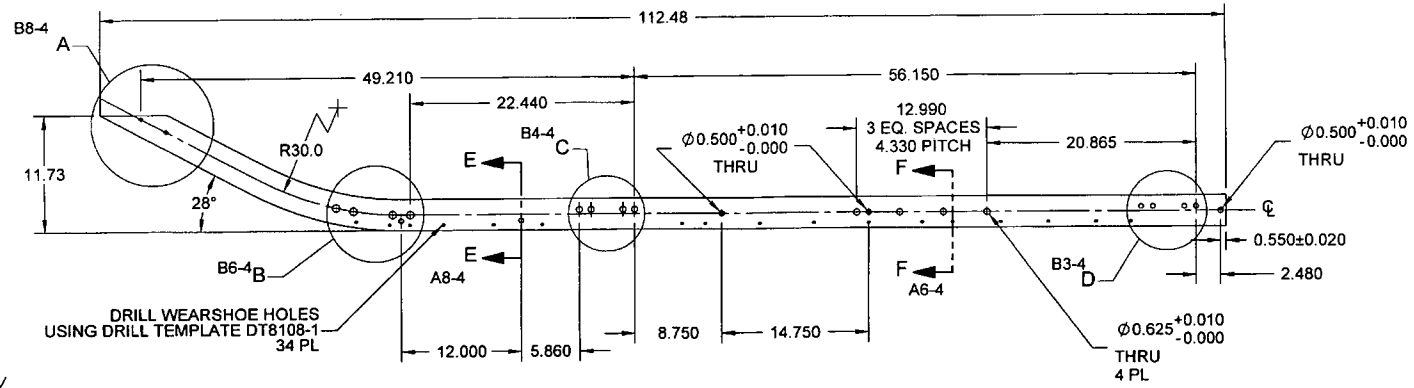
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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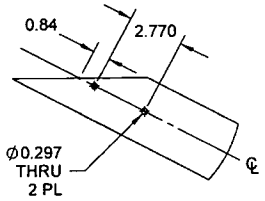
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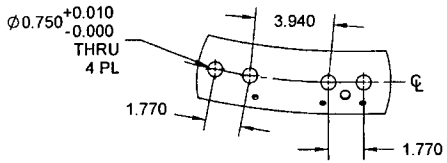
W/O 51805



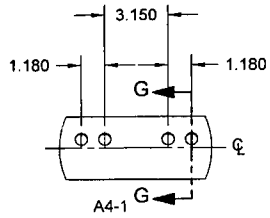
D2750-1 LH SKIDTUBE



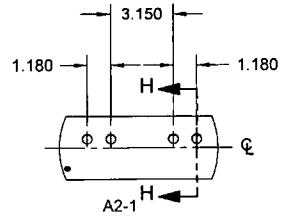
D7-4
DETAIL A
SCALE 2X



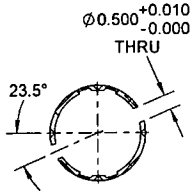
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DETAIL B
SCALE 2X



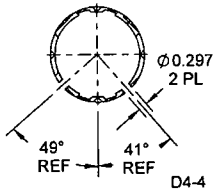
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DETAIL C
SCALE 2X



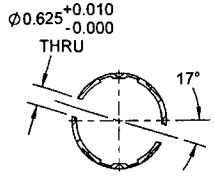
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DETAIL D
SCALE 2X



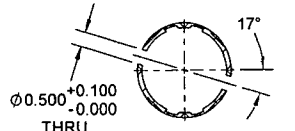
D6-4
SECTION E-E
SCALE 3X, 2 PL



D4-4
SECTION F-F
SCALE 3X, 17 PL



B4-4
SECTION G-G
SCALE 3X, 4 PL



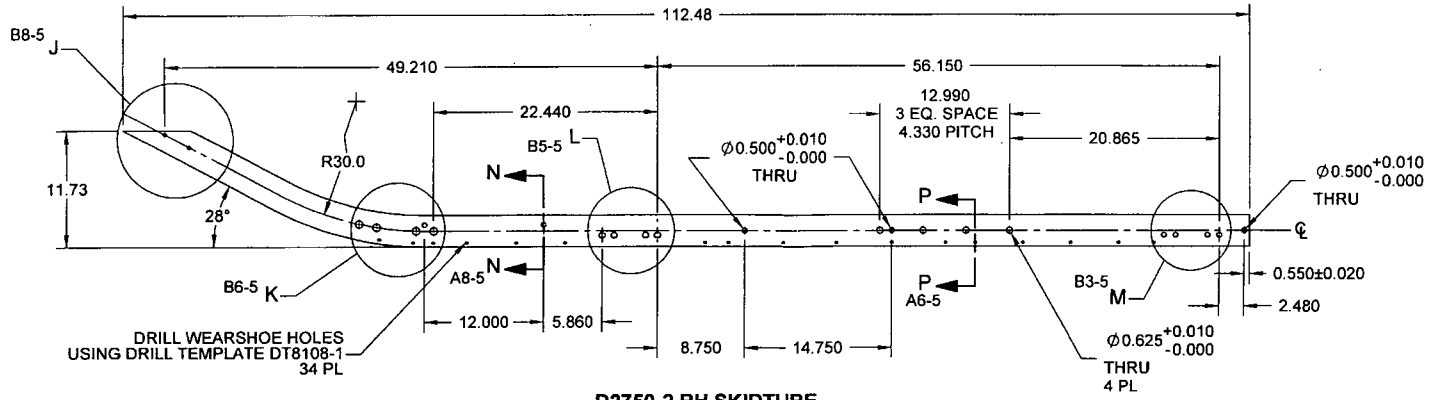
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SECTION H-H
SCALE 3X, 4 PL

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08.09.22

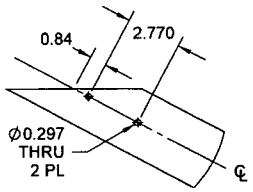
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DATE	08.07.16	

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w/o 51805

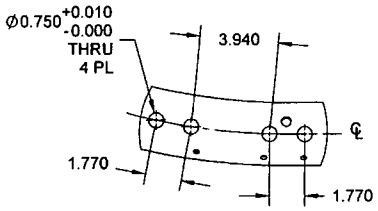


D2750-2 RH SKIDTUBE



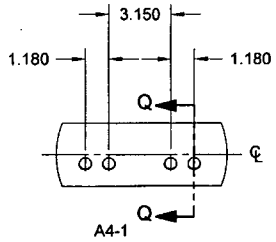
D8-5

DETAIL J
SCALE 2X



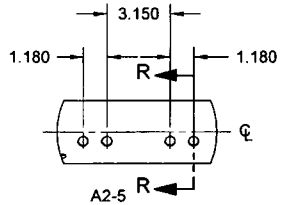
C7-5

DETAIL K
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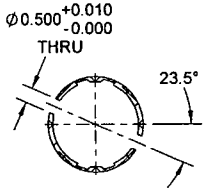
D6-5

DETAIL L
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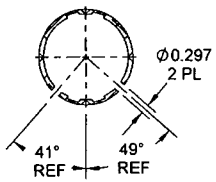
C3-5

DETAIL M
SCALE 2X



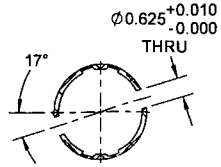
C6-5

SECTION N-N
SCALE 3X, 2 PL



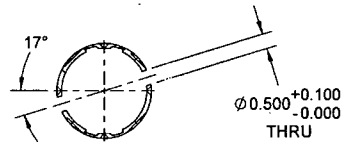
C4-5

SECTION P-P
SCALE 3X, 17 PL



B5-5

SECTION Q-Q
SCALE 3X, 4 PL



B3-5

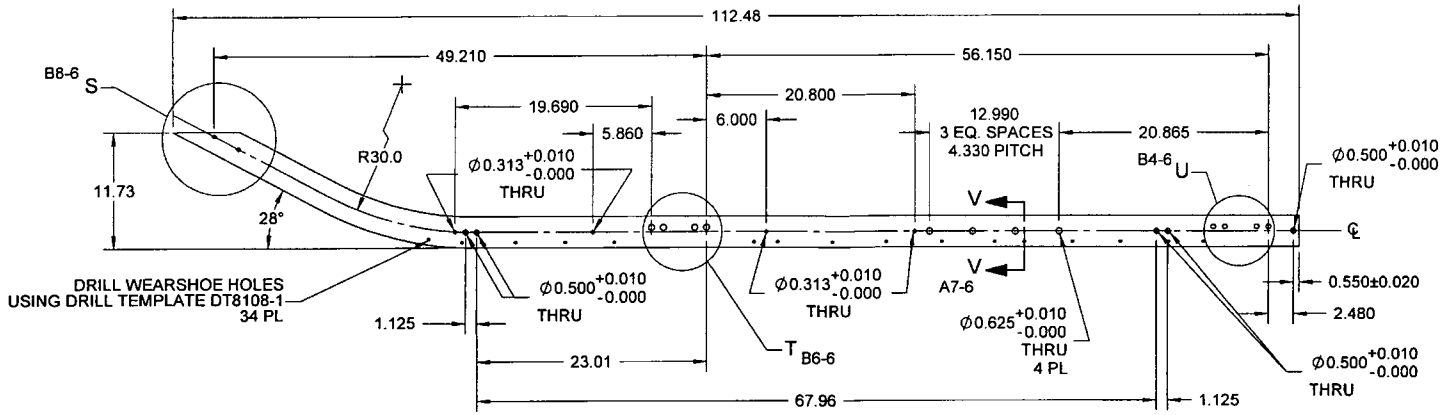
SECTION R-R
SCALE 3X, 4 PL

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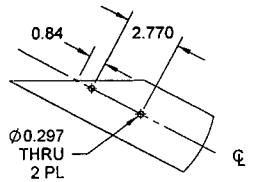
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 REV. F
CHECKED		SHEET 5 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
APPROVED		
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DATE 08.07.16		

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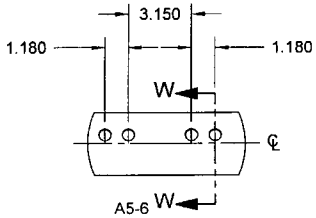
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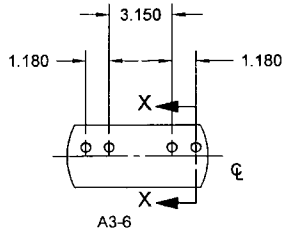
D2750-3 LH SKIDTUBE



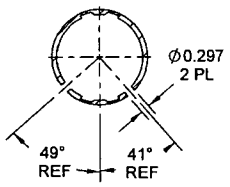
DETAIL S D8-6
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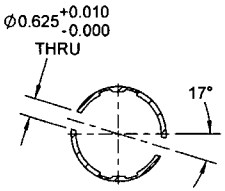
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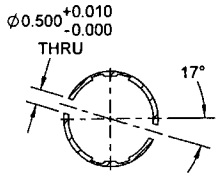
DETAIL U D3-6
SCALE 2X



SECTION V-V C4-6
SCALE 3X, 17 PL



SECTION W-W B6-6
SCALE 3X, 4 PL



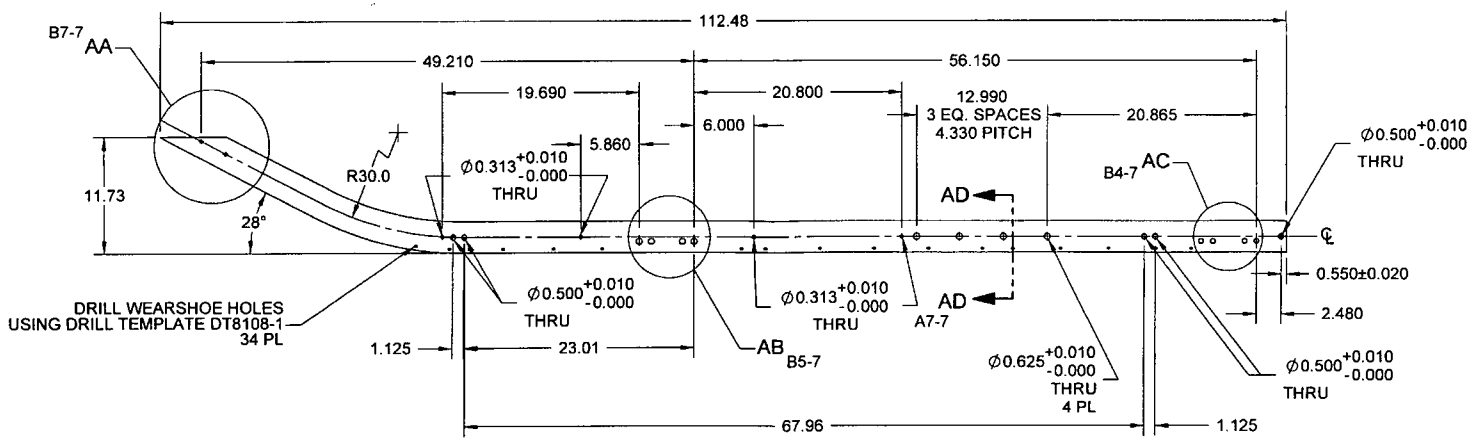
SECTION X-X B4-6
SCALE 3X, 4 PL

RELEASED
08.09.22 VH

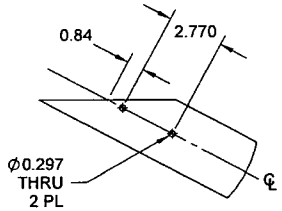
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CHECKED		DRAWING NO. D2750 REV. F
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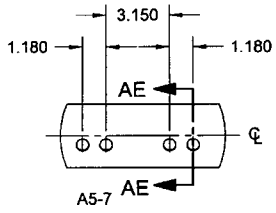
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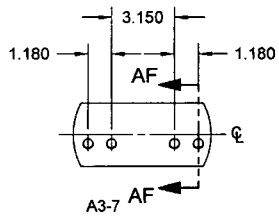
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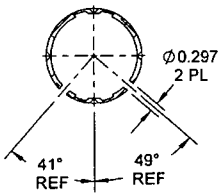
DETAIL AA D7-7
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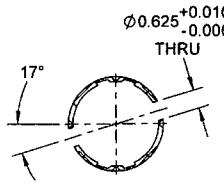
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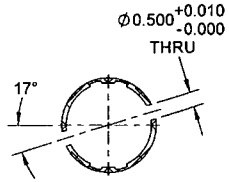
DETAIL AC D3-7
SCALE 2X



SECTION AD-AD D3-7
SCALE 3X, 17 PL



SECTION AE-AE B6-7
SCALE 3X, 4 PL



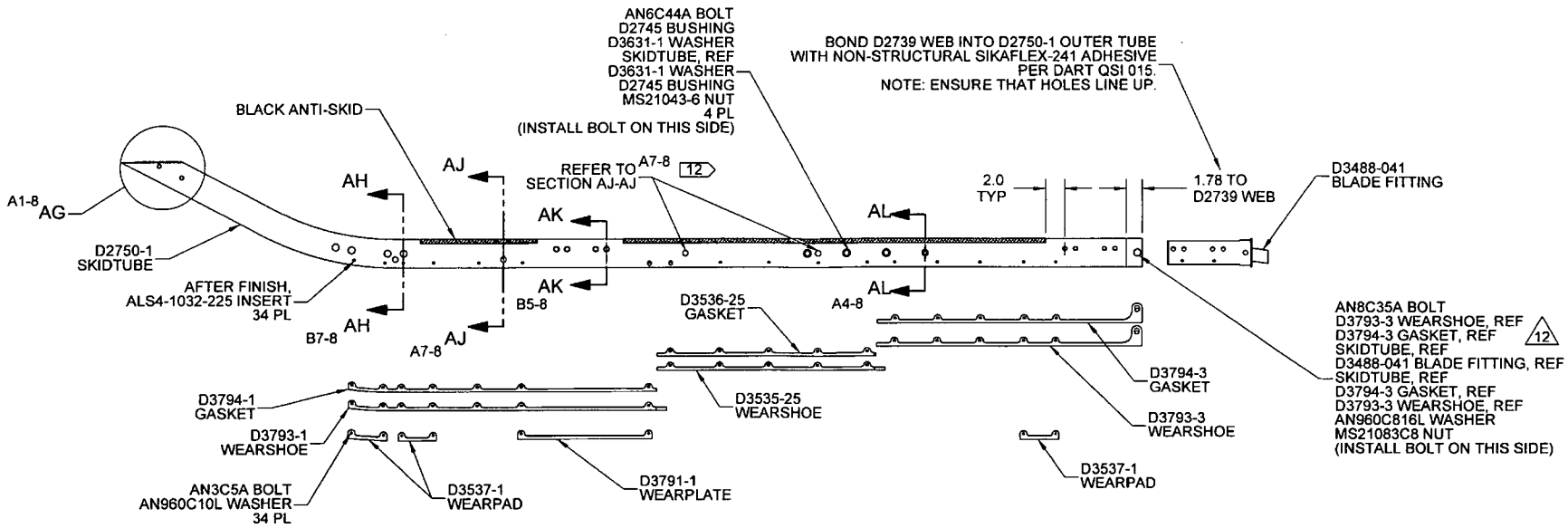
SECTION AF-AF B4-7
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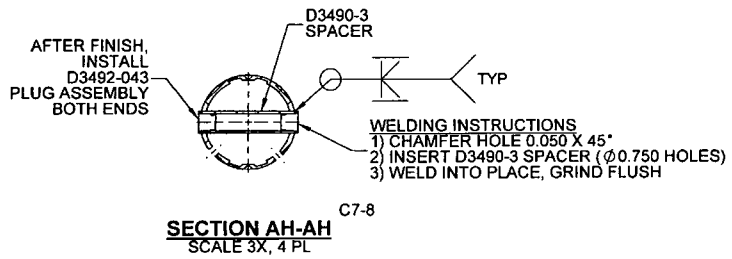
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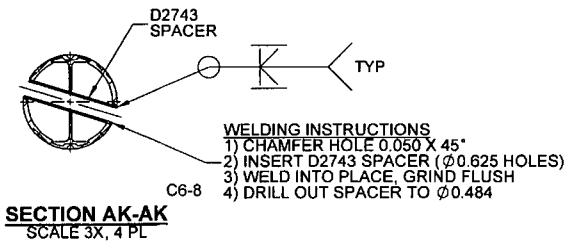
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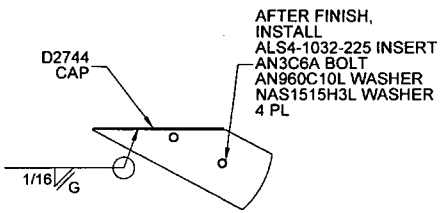
D2750-041 350 SKIDTUBE ASSEMBLY, LH



SECTION AH-AH
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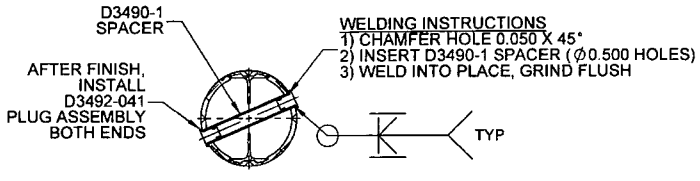


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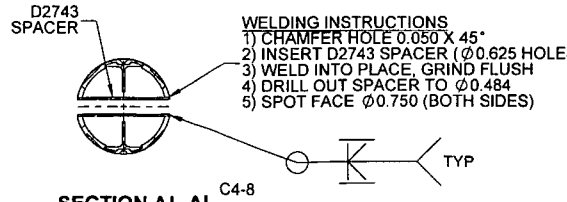


DETAIL AG
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D8-8

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05.09.22



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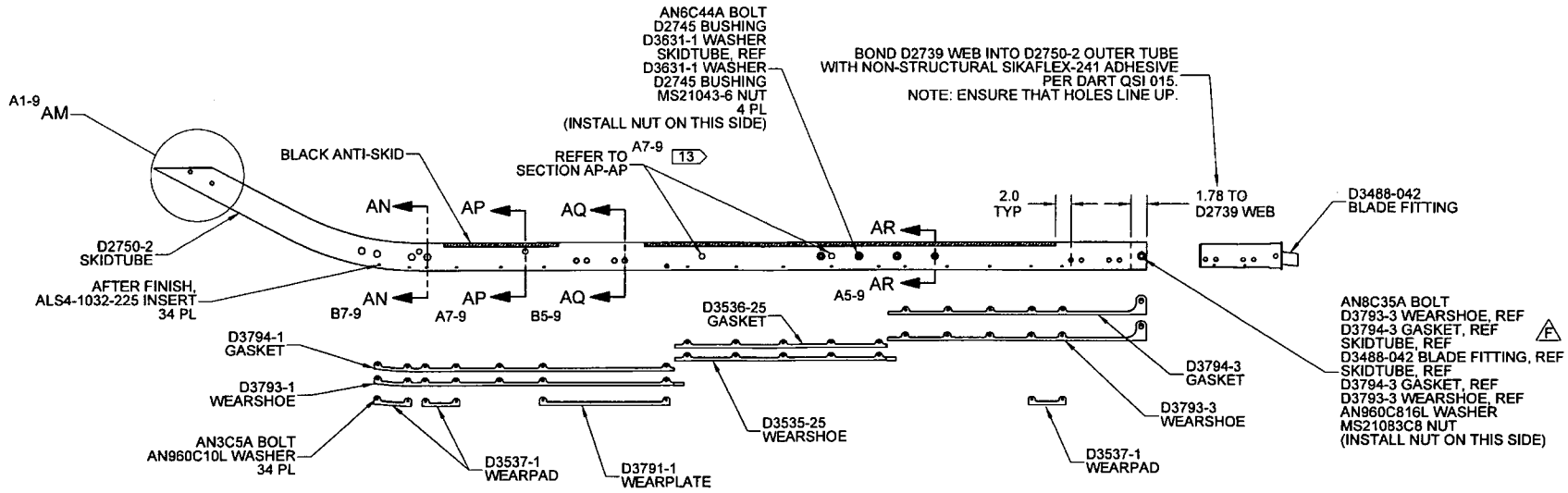


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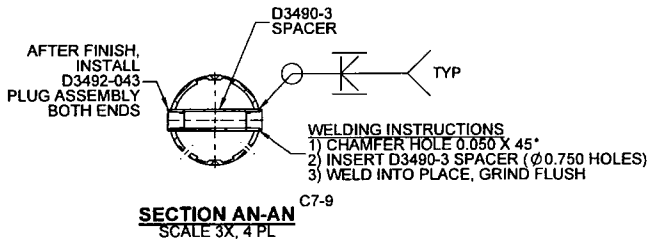
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DRAWN	PH	
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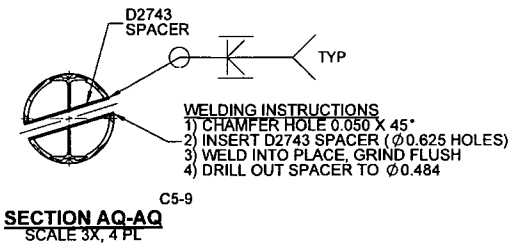
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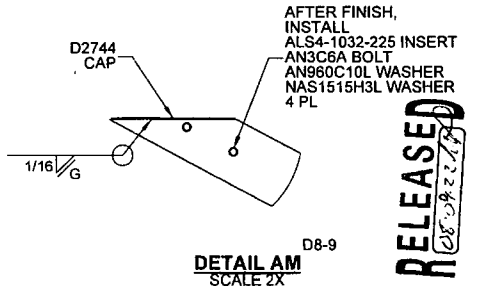
D2750-042 350 SKIDTUBE ASSEMBLY, RH



SECTION AN-AN
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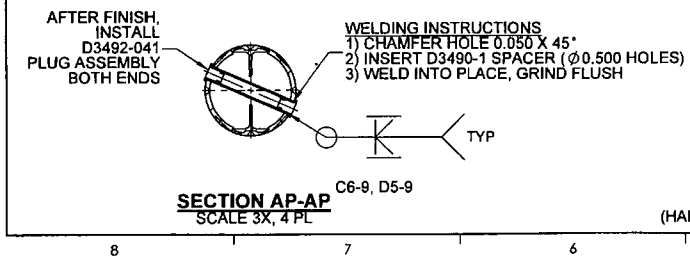


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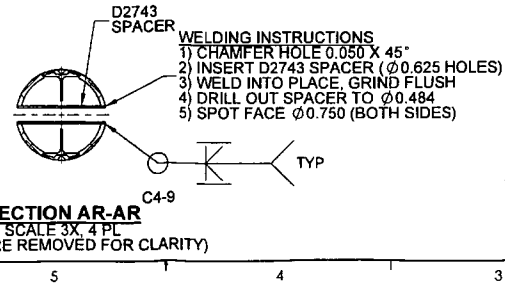


DETAIL AM
SCALE 2X

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SECTION AP-AP
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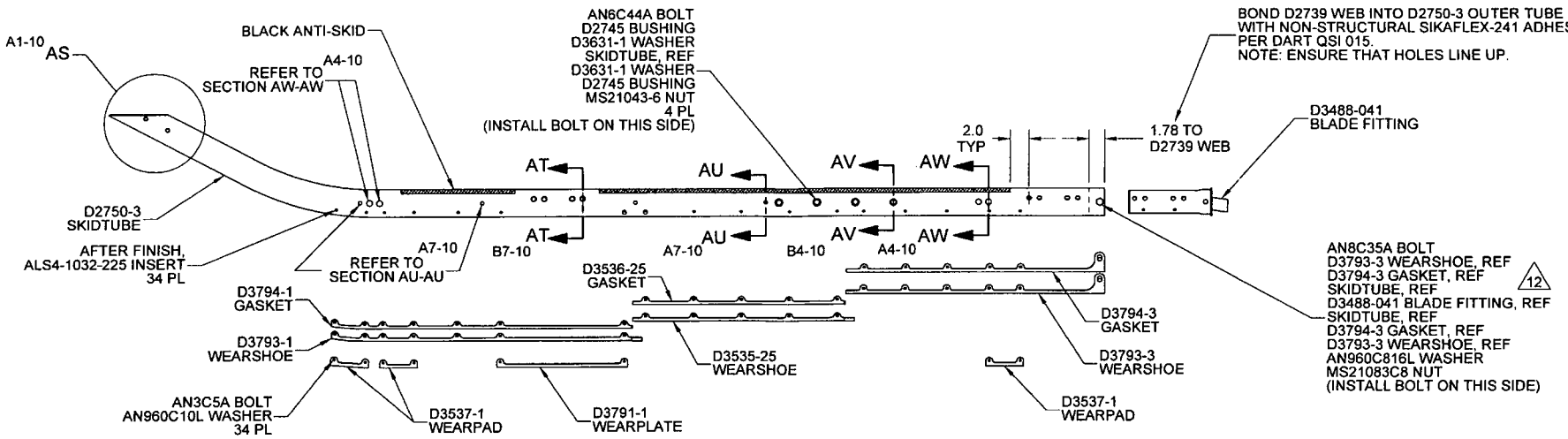


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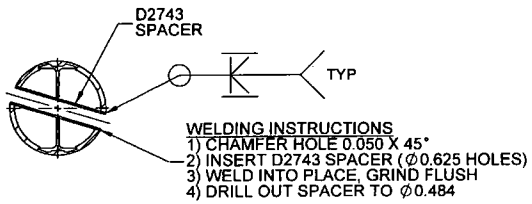
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DRAWN	PH	PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750 — REV. F
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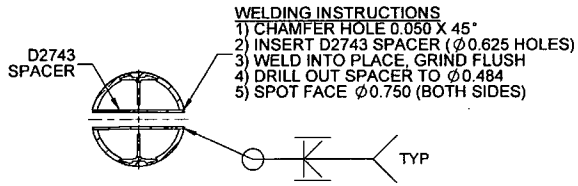
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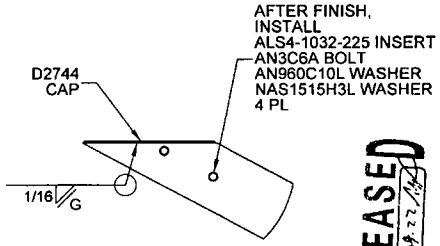
D2750-043 350 SKIDTUBE ASSEMBLY, LH



SECTION AT-AT
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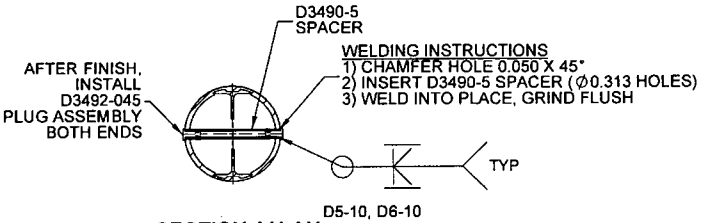


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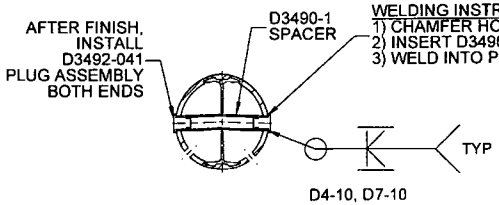


DETAIL AS
SCALE 2X

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SECTION AU-AU
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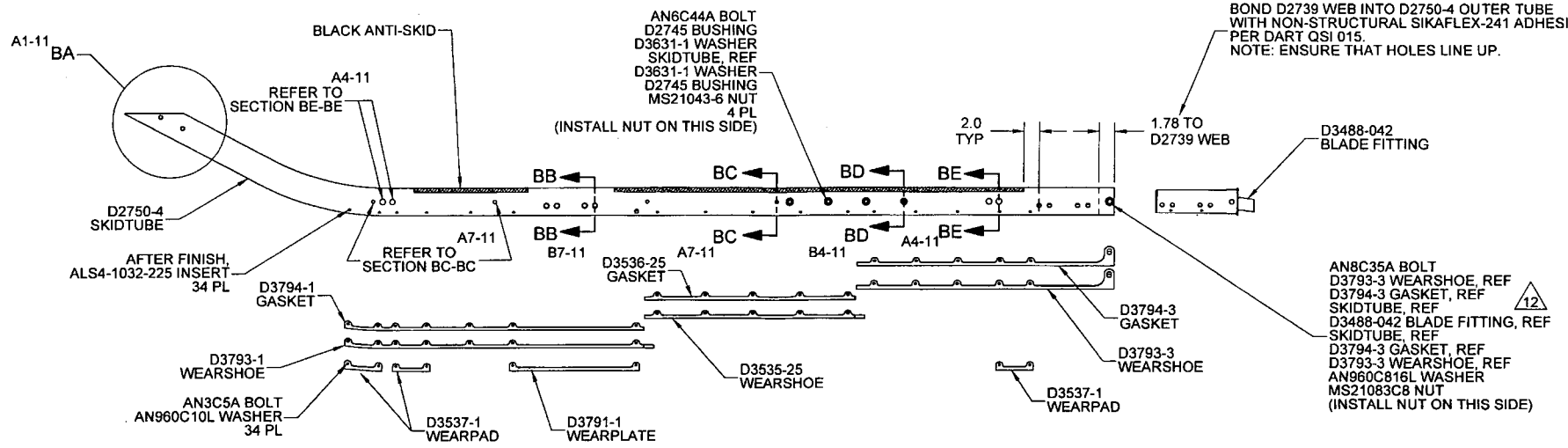


SECTION AW-AW
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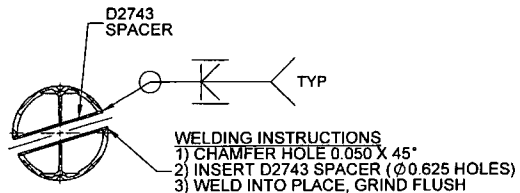
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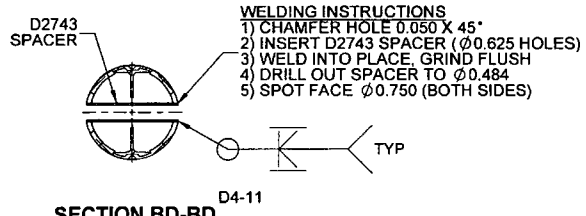


D2750-044 350 SKIDTUBE ASSEMBLY, RH

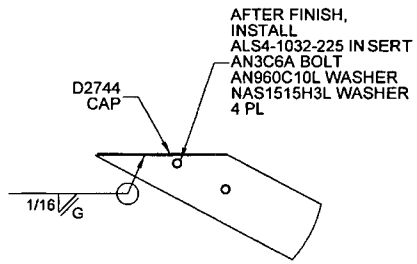
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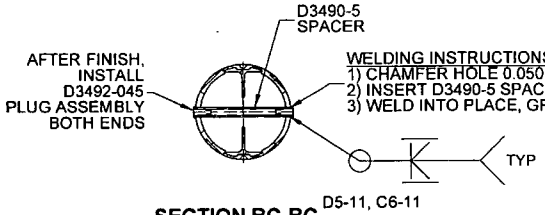
SECTION BB-BB
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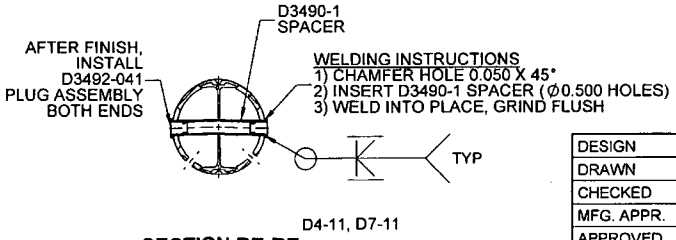
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 11 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 08.07.16		

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NO. 203

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 50111
Part number: D350 636 014
Description: 350 skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Aluminum
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[]
Penetration:	pass[✓] fail[]

UNACCEPTABLE

Cracks:	pass[✓] fail[]
Undercut:	pass[✓] fail[]
Pin holes:	pass[✓] fail[]
Overlap (cold lap)	pass[✓] fail[]
Porosity (surface):	pass[✓] fail[]
Coloration:	pass[✓] fail[]

Qualifier Pat. Dal **Date of Test Coupon** 09.07.14

Welder Barclay Elliott **Date of Test Coupon** 09.07.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld